Work Order ID 64045 Suesday, November 23, 2010 2:51:30 PM						Page 1
tem ID: D4000-3 Revision ID:	Accept			Setup	Start Stop	
tem Name: Fuel Sump Drain Fitting Start Date: 11/24/2010 Start Qty: 4.00 Required Date: 12/1/2010 Req'd Qty: 4.00 Reference:		Cust Item ID: Customer:			Стор	
Approvals: Process Plan:QC:	Date: 10 -11 - 2 Tooling: Date: SPC (Y/N):	Date:Date:		Run	Start Stop	# 1881
equence ID/ Operation Work Center ID Description	Set Up/ Run Hou		Plan Acc	cept Rej V Qty		leject Insp. Tumber Stamp
Draw Nbr Revision Nbr						· · · · · · · · · · · · · · · · · · ·
D4000 A						
00 	0.00		É	5/	6	
Doosan Lathe Turn as per Folio Rev:_ Dwg Rev:_	<u> </u>	12/01				
The state of the s	201 100	,2,00				
QC2- Inspect parts off r	machine FAI/FAIB 0.00	•	/	<u> </u>	4	
QC Memo Quality Control	0.00			<u> </u>	f	

Duit Ac	. Jopasi									
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	_ NCR:	Yes N	o DQ	4 :	_ Date: _	
	R	esolution:	Dispositi	on:	QA: N	V/C Clos	ed:		Date: _	
NCR:			WORK ORD	DER NON-CONFORM	ANCE ((NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Veritical			Approval	Approval
	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date	Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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Work Order ID 64045

Tuesday, November 23, 2010 2:51:30 PM



Page 2

Item ID:

D4000-3

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fuel Sump Drain Fitting

Start Date:

11/24/2010

Start Otv: 4.00

Rea'd Otv: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date:

Start

Stop

Run



Required Date: 12/1/2010

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Accept

Reject

Qty

Reject Insp.

Work Center ID

120

Sequence ID/

QC

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

SL 10/12/09

Tool ID

Tool # Plan

Code

Qty

Stamp Number

130

Packaging

Packaging

Identify as per dwg & Stock Location D \$

0.00

0.00

10/12/15 51

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 10/12/13_ MF 10-12-13

Dart Aerospace Ltd

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W/O:			WC	ORK ORDER CHANGES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date Qt	y Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory: I	NCR: Yes	No DQA:_	Date: _	
	R	esolution:	Dispositio	n: (A: N/C Clo	sed:	Date: _	· · · · · · · · · · · · · · · · · · ·
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DATE	STEP	Description of NC		Corrective Action Section E		Verificatio		Approval
DAIL	OIL.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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		PF _q						

NOTE: Date & initial all entries

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Page 1

Work Order ID: 64045

Parent Item:

D4000-3

Parent Item Name: Fuel Sump Drain Fitting



Start Date: 11/24/2010

Required Date: 12/1/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

Ipp Rev:A New Issue 10-01-28 JLM Verified By:EC

	3010-362 EC	verified by:DD										
Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date
Item Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand		Qty	Issued	Issued

Purchased

No

IPP rev B 10.05.13

0.232

Issued

Status

M6061T6R1.500

100

f

15.9700

0.0551

6061-T6 Round Bar 1.50

Location MAT013

110167

Loc Qty 15.97

15.97

Loc Code

Dart Aerospace

W/O:			. V	VORK ORDER CHANG	ES		•	
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:_	Date: _	
	Re	solution:	Disposit	ion:	_ QA: N/C Clo	sed:	Date: _	
NCR:	3		WORK OR	DER NON-CONFORMA	ANCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Secti		Verification	on Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector
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NOTE: Date & initial all entries

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5 4 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4000-3 JCA-M47-1-05 #le4045 _CHAMFER 0.020 X 45° R0.69 -1/8 NPT-1.06 Ø0.26^{+0.01} Ø0.34 -CHAMFER 0.18 X 45° - 0.66 SECTION D-D **D4000-3 FUEL SUMP DRAIN FITTING**

NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS4160) REF DART SPEC M6061T6R

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

DESIGN DRAWN	1		DSPACE LTD DNTARIO, CANADA
CHECKED	13	DRAWING NO.	REV. A
MFG. APPR.	B	D4000	SHEET 4 OF 8
APPROVED	10	TITLE	· SCALE
DE APPR.	-	FITTING	NTS
DATE 10.02	.10	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND NOT TO BE USED FOR ANY PURPOSE OR COPIED OF	Y DART AEROSPACE LTD OR SUPPLED ON THE EXPRESS CONDITION THAT IT IS RECOMMUNICATED TO ANY OTHER PERSON WITHOUT OWN DART AEROSPACE LTD

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W/O:			W	ORK ORDER CHANGE	S				
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Part No	:	PAR #:	_ Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	esolution:	_ Dispósitio	n:	QA: N/C	losed:		Date: _	
NCR:		W	ORK ORD	ER NON-CONFORMA	VCE (NC	R)		,	
		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order: 64045	
Description: Fuel Supply Drain Fitting	Part Number: D4000-3	B
Inspection Dwg: D4000 Rev: A	Page 1 of	1

FIRST ARTICLE INSPECTION CHECKLIST

60(c)(o)

0/2/06

	TIKOT AKTIOLE INOT COTICA CITEOREIO											
	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
,	R 2.69	+/-0.030	7.69			Uell	511-9					
	1.06	+/-0.030	1.060									
	0.16	+/-0.030	-157									
	0.020 x 45°	+/-0.010 x 0.5°	.0254450									
	0.71	+/-0.030	112									
	Ø0.26	+0.000-0.000	0.267									
	Ø0.34	+0.006/-0.001	0.340			/						
	0.51	+/-0.030	530			7						
	0.66	+/-0.030	.657									
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Measured by:	Audited by:		Preliminary Approval:	N/A
Date: 10/12/06	Date:	10/12/09	Date:	N/A

Rev	Date	Change	Revise	d by		Approved
Α	10.08.03	New Issue	KJ '	XX	7	M
				1/1		

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Dail	MCI	uspac	e Ltd

	USPACE	Ltd								
W/O:				WORK ORDER	CHANGES					
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:		PAR #:	Fault Category:	NCR	: Yes	No DQ	V :	Date:	
	Re	solution:		Disposition:	QA:	N/C C	losed:		Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
•		Description of NC	T	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A			gn & Date			
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NOTE: Date & initial all entries